



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74999

Friday, October 14, 2011 2:49:45 PM

\*74999\*

Page 2

Item ID: D3261-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Battery Case Tray

Stop

\*NS2\*

Start Date: 10/14/2011 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

ark 11/12/12

4 0

\*130\*

QC

Quality Control

140	Identify as per dwg & Stock Location:	144	0.00
*140*	Memo		

Packaging

Packaging

11/12/12 (8)

150	QC21- Final Inspection - Work Order Release	0.00
*150*	Memo	

QC

Quality Control

11/12/13 (10)

MF  
11-12-13

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# Picklist Print

Friday, October 14, 2011 2:49:44 PM

Page 1

Work Order ID: 74999

Parent Item: D3261-1

Start Date: 10/14/2011

Required Date: 10/21/2011

Parent Item Name: Battery Case Tray

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B04.12.02 Material no longer cut in-house KJ/JLM  
IPP Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB750 UHMW .750 sheet		Purchased	No			100	sf	8.0000	1.9	8			

Location	Loc Qty	Loc Code
MAT018	8	
109986	8	

18111-1

109986

4

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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD		Work Order: 74999
Description: Battery Case Tray (Dual Battery Rack)	Part Number:	D3261-1
Inspection Dwg: D3261	Rev: A2	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	✓		FK-05	Tape.
18.00	+/-0.005	18.00	✓		"	"
12.25	+/-0.030	12.25	✓		"	"
9.75	+/-0.030	9.75	✓		"	"
1.27	+/-0.030	1.254	✓		FK-04	Vern.
11.00	+/-0.030	11.00	✓		FK-05	Tape
Ø0.191	+0.005/-0.001	.191	✓		FK-04	Vern.
0.50	+/-0.010	.505	✓		"	"
0.49	+/-0.03	.49	✓		"	"
2.00	+/-0.010	1.980	✓		"	"
10.00	+/-0.010	10.00	✓		FK-05	Tape.
1.00	+/-0.010	1.005	✓		FK-04	Vern.
2.13	+/-0.010	2.130	✓		"	"
Ø0.386	+0.005/-0.001	.386	✓		"	"
4.00	+/-0.005	4.00	✓		"	"
0.75	+/-0.030	.75	✓		"	"
0.125	-0.010/+0.030	.145	✓		"	"
0.55	+/-0.030	.55	✓		"	"
0.50	+0.000/-0.030	.485	✓		"	"
0.67	+0.000/-0.030	.67	✓		"	"

Measured by:	FK	Audited by:	Onf	Prototype Approval:	N/A
Date:	1/12/10	Date:	1/12/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49,+/-0.010 was 0.610 +/-0.03	KJ/JLM	
C	08.11.27	0.67 dimension added	KJ/EC	

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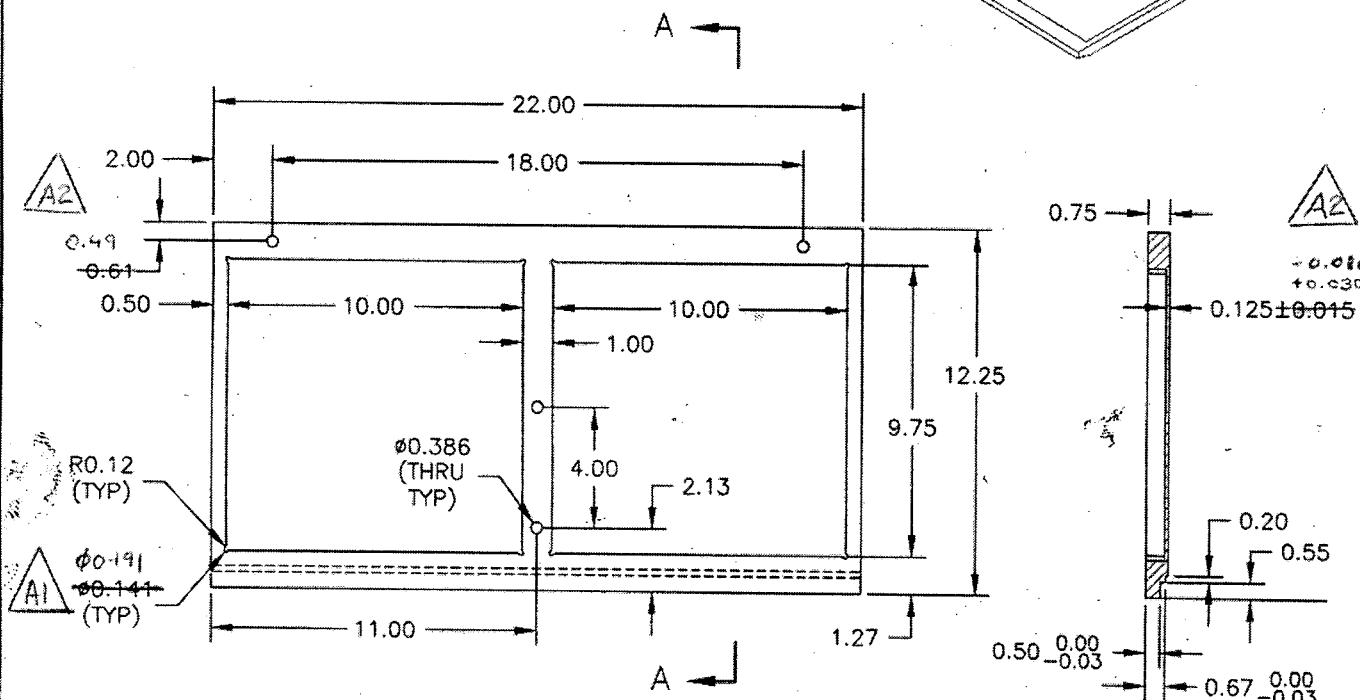
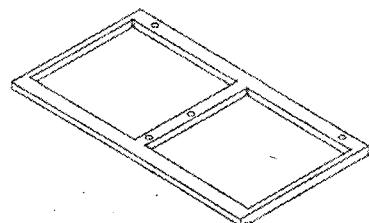
NOTE: Date & initial all entries



DESIGN <i>RF</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>IP</i>	APPROVED <i>JH</i>	DRAWING NO. D3261	REV. A	SHEET 1 OF 1
DATE 04.04.06		TITLE BATTERY CASE TRAY	SCALE 1:6	
A	04.04.06	NEW ISSUE		
A1	<del>IP</del> 04.05.14	$\phi$ 0.191 WAS $\phi$ 0.141		
A2	<del>JH</del> 04.06.08	0.125 $^{+0.010}_{-0.030}$ WAS 0.125 $\pm$ 0.015; 0.49 WAS 0.61		

RELEASER  
04.04.27 ✓

04.04.27 4



UNDER REVIEW

D3261-1

**SECTION A-A**

#### NOTES.

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) TOLERANCES ARE PER DART QSI:018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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